

## INSTALLATION INSTRUCTIONS

### 664HD, 665HD, and 681HD

New doors should be 3/16" undersize for hinge clearance between the door and frame.

All standard length hinges are non-handed and can be used for right or left-hand doors. Standard length hinges are supplied at the nominal door height.

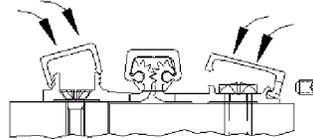
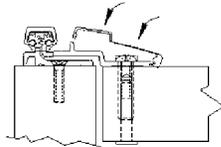
**CUTTING**- If a hinge must be cut, use a hacksaw cutting one end only. With the hinge closed and standing with cap up or on its side with cap closest to you, cut so that you cut through the cap first. If you cut off a set screw bearing, re-install it on the hinge. The hinge becomes handed after cutting and must be installed with the cut end at the bottom to allow chips to work out and to keep the templated hole pattern at the top.

**TO POSITION NEW DOOR**- Remove existing hinges/pivots from the existing door and frame. Place the new door in the opening and shim so that the door is plumb and square. Clearances between door and frame should be 1/8" from the top and 1/8" on the lock side. For 664HD there must be at least 7/8" of door frame. If there is more than 7/8", mark an alignment line on the frame face from 1" up to 1-15/16" way from the center of the gap between the jamb and the door. The 664HD has a 1/16" door inset. If needed, a continuous shim may be installed under the door leaf for a deeper inset. Contact factory for shims and installation instructions.

**INSTALLING HINGE**- Line up the hinge with the frame or the alignment line, making sure that the base does not protrude beyond the frame. Drill #13 or 3/16" dia holes, using one hole at the top and one hole at the bottom and attach the frame leaf at using the 12-24 flat head screws provided. Now attach the door leaf to the door through two of the locator holes using the TEK screws supplied. Remove shims and check door clearances. If door sags slightly, note amount of adjustment needed to bring door back into alignment. Then locate and mark (using 3/8" X 1 transfer punch) for the top and bottom thrubolts in the door. Remove door and drill holes with 3/8" dia. drill. Re-hang the door with the top and bottom thrubolts and make any necessary adjustments to the frame leaf. When door is aligned, finish securing the frame leaf with the flat head screws. Mark and drill the remaining thrubolt holes in the door and install the remaining thrubolts and 1/4-20 shoulder screws.

For extra security, apply a bead of construction or panel adhesive inside the door leaf molding or over the sex bolt heads

**INSTALLING COVER**- Before installing the door leaf cover, check that the 3 set screws do not protrude into the interior of the cover. Line up the end of the cover with the top end of the hinge. Starting at the top, apply pressure along the length of the cover and snap into place as you go down the length of the hinge. If using a hammer, use a block of wood to protect the cover. When the cover is on, tighten the 3 set screws to secure it. To install the frame leaf cover start by hooking it onto the outside edge of the frame leaf. Starting at the top, apply pressure along the length of the cover and snap into place as you go down the length of the hinge. If using a hammer, use a block of wood to protect the cover.



NOT FOLLOWING INSTALLATION INSTRUCTIONS MAY RESULT IN IMPROPER INSTALLATION AND VOID THE MANUFACTURER'S WARRANTY.

664HD & 665HD SCREW DETAIL	
	DESCRIPTION
FRAME	12-24 X 3/4" PH. F.H. UNDERCUT SELF DRILLING THREAD FORMING TEK SCREW
DOOR	1/4-20 X 1-9/16L. X 3/8 DIA. SEX BOLT & 1/4-20 X 1" PH. HEAD SHOULDER SCREW
	12-24 X 11/16 PH. PN. HD. SELF DRILLING TEK SCW. (LOCATOR HOLE)

681HD SCREW DETAIL		
		DESCRIPTION
FRAME TO DOOR	FRAME	12-24 X 11/16" PH. PAN HEAD SELF DRILLING THREAD FORMING TEK SCREW
	DOOR	1/4-20 X 1-9/16L. X 3/8 DIA. SEX BOLT & 1/4-20 X 1" PH. HEAD SHOULDER SCREW
DOOR TO DOOR	DOOR	12-24 X 11/16 PH.PN. HD. SELF DRILLING TEK SCW. (LOCATOR HOLE)
		1/4-20 X 1-9/16L. X 3/8 DIA. SEX BOLT & 1/4-20 X 1" PH. HEAD SHOULDER SCREW
	DOOR #1	12-24 X 11/16 PH.PN. HD. SELF DRILLING TEK SCW. (LOCATOR HOLE)
		1/4-20 X 1-9/16L. X 3/8 DIA. SEX-BOLT & 1/4-20 X 1" PH. HEAD SHOULDER SCREW
DOOR #2	12-24 X 11/16 PH.PN. HD. SELF DRILLING TEK SCW. (LOCATOR HOLE)	
	1/4-20 X 1-9/16L. X 3/8 DIA. SEX-BOLT & 1/4-20 X 1" PH. HEAD SHOULDER SCREW	

# STANLEY

dormakaba USA Inc.  
6161 East 75th Street  
Indianapolis, IN 46250 USA  
Customer Service: 1-855-365-2407

[stanleyhardwarefordoors.com](http://stanleyhardwarefordoors.com)

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